



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4931-3
Job Sheet 196479



Part No: D4931-3

Job Qty: 10 pcs

Part Name: Engine Fitting (For B3 Models)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/15/19

Created By: Lorin Baltac

Type: Stock

Description:

Note: DWG REV A SHEET 2 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs		7/15/19	1.00	9.90	Doosan - 1		
110	QC 2	10 pcs		7/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

DAS
5
9-89

DAS
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9-89



Container No: S192905



Part: D4931-3

Job No: 196479

Serial No/Batch: S192905

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/23/19

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
112	Conventional Mill - 1 - B4B	10 pcs	7/15/19	0.00 3.82	Conventional Mill - 1 - B4B	10
					Conventional Mill - 2 - B4B	
115	QC 2	10 pcs	7/15/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	19/7/11
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	QC 8	10 pcs	7/15/19	0.00 0.00	QC 8 - 12	19/07/11
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	

				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130	Packaging 3-2 - Stock - B4B	10 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA	10 pcs	7/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

PC ST127

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Part Op 100 - Doosan Lathe)Machine as per folio FB210
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB)
 112 - (Manufacture as per dwg)DRILL HOLES AS PER REQUIRED
 115 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release

1189 balance

19/8

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	1.5000 ft (.15 ea)	100-Doosan - 1	5166566 5163533 5166106

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	2	16	0
Part Specifications				
Specifications could not be found.				

Plex 6/13/19 11:39 AM Dart.Baltac.Lorin

DART AEROSPACE LTD		Work Order:	
Description: EAPS P2 Engine Fitting		Part Number:	D4931-3
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	Maj: 1.0608 Min: 1.0494	1.058	✓		Micrometer	
M.O.W.	Maj: 1.0995 Min: 1.0938	1.097			Wipe off	
0.13 x 45°	+/-0.030 x +/-0.5°	.126 x 45°			Caliper	
Ø0.063	+0.004/-0.001	.065			caliper	
0.08	+/-0.030	.082			caliper	
0.906	+/-0.010	.910				
0.13	+/-0.030	.132				
0.25	+/-0.030	.251				
0.938	+/-0.010	.941				
1.927	+/-0.010	1.927				
0.250	+/-0.010	.248				
0.424	+/-0.010	.427				
0.315	+/-0.010	.313				
0.185	+/-0.010	.185				
37°	+/-0.5°	37°				
0.33	+/-0.030	.34				
34°	+/-0.5°	34°				
0.532	+/-0.010	.533				
1.063	+/-0.010	1.06	✓			
0.594	+/-0.010	0.594	✓		Vernier JVD5	
0.791	+/-0.010	.789	✓		Caliper	
1.188	+/-0.010	1.188	✓			
1.582	+/-0.010	1.582	✓		caliper	
0.238	+0.005 -0.001	0.239	✓		Vernier JVD5	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 19/7/11	Date: 19/07/11	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	<i>[Signature]</i>